

Not for Production FAI ~~DO~~ ONLY

Work Order ID 133824

133824

Page 1

Thursday, June 18, 2015 2:56:57 PM

Item ID: D4842-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Cutter Assembly

Start Date: 6/18/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4842

REV B

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: _____

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

Test ONLY
AS7.22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 133824***133824***

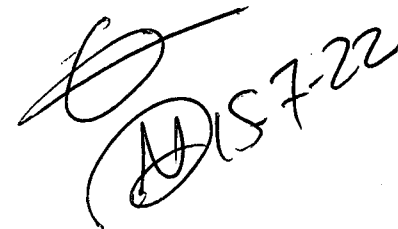
Page 2

Thursday, June 18, 2015 2:56:57 PM

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Cutter Assembly
Start Date: 6/18/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/25/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Picklist Print

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Page 1

Work Order ID: 133824

133824

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 6/18/15

Required Date: 6/25/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1 Blade		Manufactured	No				Each	14.0000		2			
D4839-1													
Back to stock													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			14						
					124649		4						
					133453		10						
D4842-1 Lower Cutter Deflector		Manufactured	No				Each	8.0000		1			
D4842-1													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			8						
					100670		1						
					107947		3						
					109250		4						
D4842-3 Lower Cutter Body, LH		Manufactured	No				Each	5.0000		1			
D4842-3													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			5						
					107957		3						
					109251		2						

B 100700 X 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
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Picklist Print

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Work Order ID: 133824

133824

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 6/18/15

Required Date: 6/25/15

Start Qty: 1.00

Required Qty: 1.00

D4842-4

Manufactured No

Each

10.0000

1

D4842-4

Lower Cutter Body, RH

Location

Loc Qty

Loc Code

MF

10

108070

1

109252

9

Each

1,045.000

6

MS21042L08

Purchased

No

MS21042L 08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

623

m131697

623

ST304

321

123900

16

m128401

102

m131317

203

Each

533.0000

6

MS27039-08-19

Purchased

No

MS27039-08-19

Screw

Location

Loc Qty

Loc Code

ST273A

450

m131317

450

ST281

83

m131264

83

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, June 18, 2015 2:57:01 PM

Page 3

Work Order ID: 133824

133824

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 6/18/15

Required Date: 6/25/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

3,257.000

12

NAS1149FN832P

Washer

Location

Loc Qty

Loc Code

ST260a

1726

125268

1726

st268

1531

125268

602

MT30388

929

12 7/8

DQA: _____ Date: _____



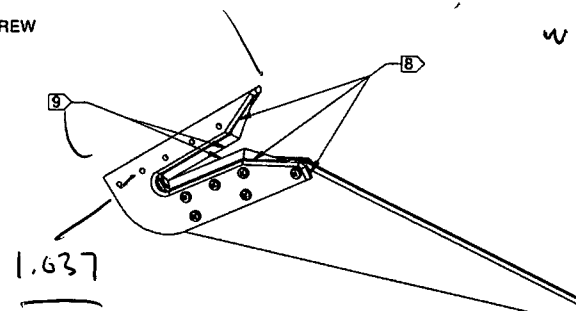
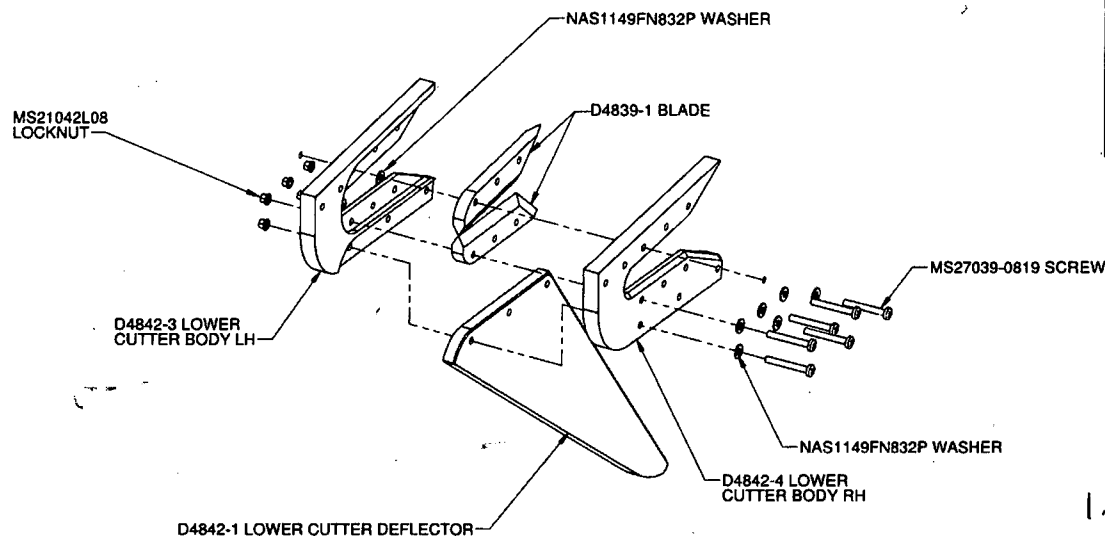
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

ITEM	QTY	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



H=12.47
L=13.28
W=0.883

D4842-041 LOWER CUTTER ASSEMBLY

RELEASED
2013-10-31

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL MATING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	AP	D4842	SHEET 1 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	